

D206-628-012 BULK

split

24

Date: Wednesday, 5/16/2007 1:29:44 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 32391A -2  
 Estimate Number : 11702  
 P.O. Number : N/A  
 This Issue : 5/16/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LARGE FAB ASSY  
 Previous Run : 32249A  
 Drawing Name : 206L /407 STEP ASSY, LH  
 Part Number : D2724041  
 Drawing Number : D2724 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material : N/A  
 Due Date : 6/15/2007 Qty: 4 Um: Each  
 Written By : Don.05.16  
 Checked & Approved By : Don.05.16  
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Qty Part # Description Batch:  
 1 D2622-120C Extrusion 331984

Check Material for any Dents or Defects

F.F.

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724  
 Deburr and bevel ends for welding

Q. Alex Mearse 07-05-31

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 206 Step Endplate

Pick:

Qty Part Number  
 2 D2734

Description  
 End Cap

Batch

329340

PLATE

KE.07.05.31

4.0

D34581



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Pick:

Qty Part Number  
 2 D3458-1

Description  
 Plate

Batch

331013 = 8

KE.07.05.31

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32391A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch 31074=8

2

D3458-3

Plate

834

SE.07.05.31 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch: M102756  
M103317

Grind end cap welds flush

u.m 07.06.04 (4)

SE

SE.07.06.01 4

SE.07.06.01 4

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

(LH) 07/06/05 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.06.05 (4) (LH)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SE.07.06.07 4

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.06.07 (4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

SE.07.06.11 4



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# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32391A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig  
DT  
A/R AL ROD Batch: M102756

*07.06.11* 4

Grind per dwg D2724

*from 07.06.12*

12.0

QC5/9

WELD INSPECTION



*QC5 07.06.13 (4)*



Comment: WELD INSPECTION

*LH*

*07/06/13*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*(4X)*

Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

*M-L*

*07/06/16*

14.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

*P/O: 4058 C207/06/27 (2)*

*(2)*

-PRIME

-PAINT DELFLEET BLUE (PER QSI 005)

-CLEAR DELFLEET

15.0

QC14

INSPECT SPRAY PAINT



*070703 (2)*



Comment: INSPECT SPRAY PAINT

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*M104732*



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

*07/07/04 (2)*

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07/07/05 (2)*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

*PPR 32391*

*07/07/05 (2)*

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Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32391A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

207/07/05

Job Completion



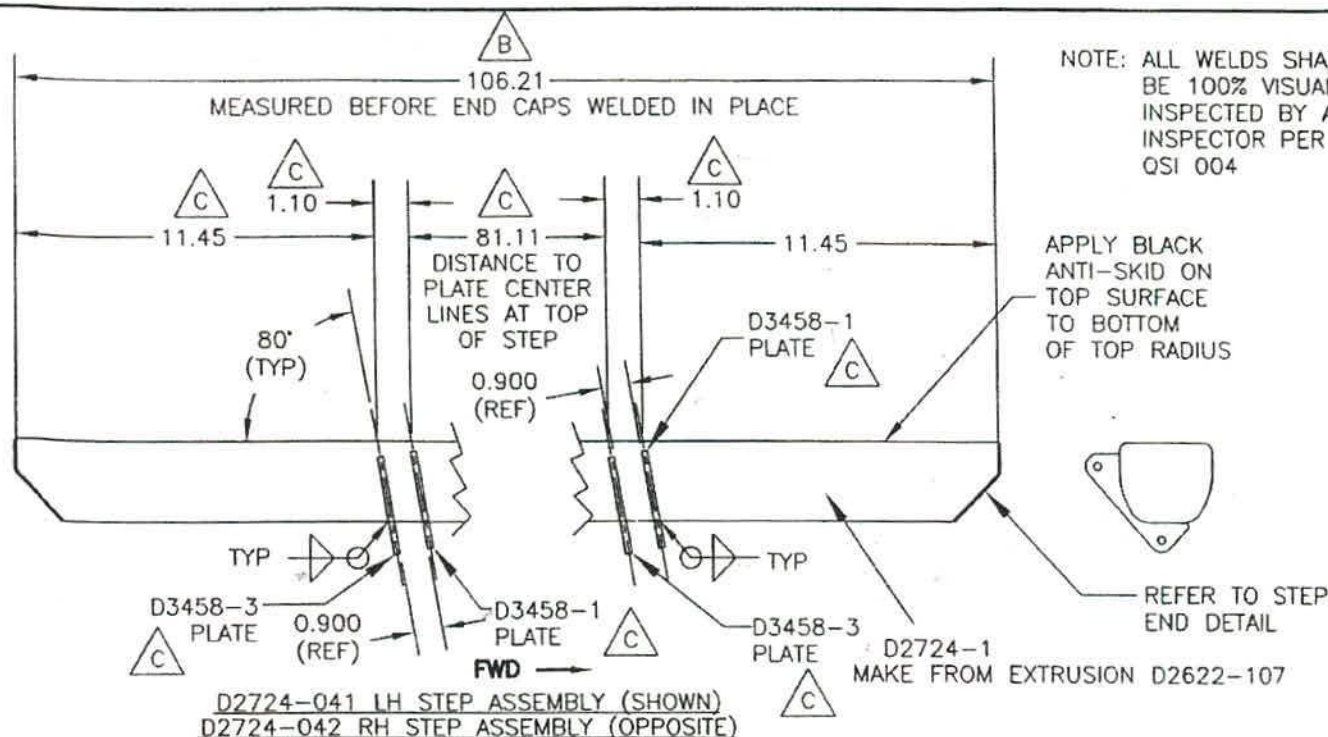
207/07/05

**DART**

RELEASED

05.11.14

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004



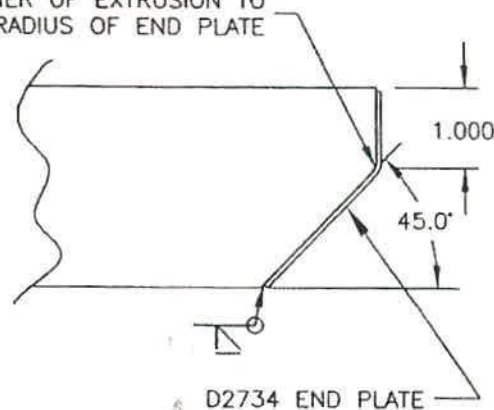
**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

**D2724-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 32391A  
WORK ORDER



DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
	A	97.12.04		NEW ISSUE
	B	98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES
	C	05.09.19		RE-DESIGN, ADD D3458-1/-3
				206L/407 STEP ASSEMBLY
				SCALE
				REV. C
				SHEET 1 OF 1